

**Work Order ID 63388**

Thursday, October 28, 2010 10:51:22 AM



Page 1

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 10/28/2010 Start Qty: 4.00

Required Date: 11/12/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9467	Rev A
IIN D206-642	Rev N

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Create White labels per PPP K642-512 CHG004

0.00

*S. L. H.*  
10/14/05

*H 10-10-25*  
*(H)*

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

*10/11/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63388**

Thursday, October 28, 2010 10:51:22 AM

Page 2

Item ID: K642-512

Accept

Setup Start

Revision ID:

Stop

Item Name: saddle kit 642-512

Start Date: 10/28/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-512 Location: PPP 63384

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MP  
10-11-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 05.06.07 new issue EC  
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A BOLT		Purchased	No			110	Each	68.0000	3	12			
-----------------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST353	68	
109323	6	
111724	1	
112489	31	
114523	30	

AN3C36A BOLT		Purchased	No			110	Each	115.0000	9	36			
-----------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST353	115	
109771	10	
115358	15	
115518	40	
115882	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN3C41A

Purchased

No

110

Each

111.0000

8

32



BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

107

108084

7

108409

8

112879

1

114443

59

115316

32

AN4C6A

Purchased

No

110

Each

535.0000

12

48



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST

4

103344

0

111295

4

ST356

527

113121

127

115016

200

116003

200

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

8 AN5C11A  
Bolt

Purchased No

110 Each

204.0000

8

32

Location

Loc Qty

Loc Code

FG

4

104817

4

ST338

200

108428

8

109898

8

114443

14

114455

70

114523

100

8 AN5C12A

Purchased No

110 Each

64.0000

4

16

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

62

113121

62

8 AN5C13A

Purchased No

110 Each

82.0000

4

16

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

80

111648

1

113121

29

114615

50

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W/O:		WORK ORDER CHANGES					
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Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN5C15A



Bolt

Purchased

No

110

Each

81.0000



1 4  
10/11/10

## Location

## Loc Qty

## Loc Code

ST339

81

111819

81

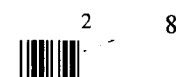
Purchased

No

110

Each

90.0000



2 8  
10/11/10

AN5C32A



## Location

## Loc Qty

## Loc Code

FG

4

18918

4

ST340

86

107013

1

107463

2

111808

33

113164

50

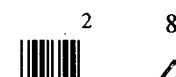
Purchased

No

110

Each

104.0000



2 8  
10/11/10

AN5C34A



## Location

## Loc Qty

## Loc Code

FG

2

18918

2

ST340

102

107289

2

110342

2

111648

38

112454

60

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN5C35A

Purchased

No

110

Each

93.0000

1

4



*10/28/10*

## Location

## Loc Qty

## Loc Code

ST340

93

107551

2

108084

45

108407

46

AN960C10L

NAS1149C0332

Purchased

No

110

Each

29.0000

24

96



*11/15/10 10/28/10*

washer

## Location

## Loc Qty

## Loc Code

ST245

29

107534

29

AN960C416L

Purchased

No

110

Each

164.0000

24

96



*11/14/10 10/28/10*

WASHER

## Location

## Loc Qty

## Loc Code

FG

44

104925

44

ST346

120

106785

10

107008

10

112612

3

112794

29

112828

27

69220

41

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

AN960C516L NAS1149C0532 Purchased No

110 Each 22.0000 8 32

WASHER



MISS 10/11/45

Location Loc Qty Loc Code

ST347 22  
103344 8  
109545 8  
111916 6

D206-648-013 GHW Modification Manufactured No

110 Each 10.0000 1 4

GHW Modification



B63329 10/11/45

Location Loc Qty Loc Code

FG120 10  
42315 1  
47600 1  
62644 8

D2652 Bushing Manufactured No

110 Each 151.0000 16 64

Bushing



10/11/45 (10)

Location Loc Qty Loc Code

FG 44  
31985 44  
ST020 107  
61645 1  
62659 106

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D2712



Set Screw

Manufactured No

110

Each

413.0000



10 40

10/11/4

## Location

## Loc Qty

## Loc Code

FG

50

29962

50

ST022

363

61331

363

Manufactured No

110

Each

14.0000



1 4

10/11/4

D2932-2



Saddle RH Out, 206

## Location

## Loc Qty

## Loc Code

ST421

4

41440

1

62637

3

ST428

10

52586

6

60253

4

Manufactured No

110

Each

4.0000



1 4

10/11/4

D2933-2



Saddle RH In, 206

## Location

## Loc Qty

## Loc Code

ST428

4

41129

1

62698

3

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D2934

Manufactured No

110 Each

20.0000

2 8



Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST031

14

59641

14

D2935

Manufactured No

110 Each

51.0000

2 8



Saddle Spacer

Location

Loc Qty

Loc Code

ST028

51

59642

6

62690

45

D2938-2

Manufactured No

110 Each

3.0000

1 4



Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST428A

3

62701

3

D2939-2

Manufactured No

110 Each

4.0000

1 4



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST428A

4

58268

1

62702

3

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Thursday, October 28, 2010 10:51:25 AM

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Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D3396-3

Manufactured No

110 Each

31.0000

2

8



Spacer



WHL48

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

21

36336

2

45667

2

58680

17

D3407-043

Manufactured No

110 Each

15.0000

1

4



Tow Ring



WHL48

Location

Loc Qty

Loc Code

ST420

8

62627

8

ST464

7

50387

7

D3456-1

Manufactured No

110 Each

3.0000

1

4



Washer



WHL48 B63298 (10)

Location

Loc Qty

Loc Code

ST058

3

54692

3

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W/O:		WORK ORDER CHANGES					
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Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

D3457-1  
Washer

Manufactured No

110 Each

13.0000



62691 10/11/10

Location

Loc Qty

Loc Code

FG 10  
32409 10  
ST059 3  
45913 1  
52981 2

D3672-1  
Phenolic Washer

Manufactured No

110 Each

847.0000



24 96 10/11/10

Location

Loc Qty

Loc Code

ST077 847  
42329 150  
52505 697

D3672-3  
Phenolic Washer

Manufactured No

110 Each

559.0000



24 96 10/11/10

Location

Loc Qty

Loc Code

ST077 559  
47023 16  
55500 32  
57704 511

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 63388

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 4.00

Required Qty: 4.00

S D3672-7  
Phenolic Washer

Manufactured No

110 Each

556.0000

24

96

Location

Loc Qty

Loc Code

ST077

556

35522

8

51696

16

53237

532

S MS21043-3  
Nut

Purchased No

110 Each

2,506.000

20

80

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2430

112314

2430

S MS21043-4  
Nut

Purchased No

110 Each

946.0000

13

52

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

906

112492

25

113069

8

114181

29

114523

244

114784

300

115936

300

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63388



Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 10/28/2010

Required Date: 11/12/2010

Start Qty: 400

Required Qty: 400

MS21043-5  
Nut

Purchased

No

110

Each

580.0000

4 16



10/11/3

SL

10

Location

Loc Qty

Loc Code

ST301

580

111819

80

112314

500

8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			AN3C4A	* BOLT <sup>(1)</sup>
5A			2			AN960C10L	* WASHER <sup>(1)</sup>
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4				AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET <sup>(1)</sup>
23A			1	1		D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET <sup>(1)</sup>
24A			1	1		D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET <sup>(1)</sup>
25A			1	1		D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET <sup>(1)</sup>
26A			78	78		AN3C4A	* BOLT <sup>(1)</sup>
26B			78	78		AN960C10L	* WASHER <sup>(1)</sup>
26C			78			ALS7-1032-130 (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	* INSERT <sup>(1)</sup>
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE  
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)